

Work Order ID 64757

Thursday, December 16, 2010 9:49:18 AM

Page 1

Item ID: D2348

Accept

Setup Start

Revision ID:

Item Name: Wearplate

Stop

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 12/21/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: PLDate: 10-12-14

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2348

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2348

Dwg Rev: EProg Rev: E

2-Deburr if necessary

⇒ Debur m/d 10/12/15

(9)

(9)

R10-12-16

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

R10-12-16

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S12/16

(49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 12/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Debur

7 m-l 12/12/15

(14)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/12/16

(79)

150

0.00



Outsource process-Anodize per QSI017 4.1.10.1

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O:

13162

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

CL 10/12/17 (9)

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NOTE: Date & initial all entries


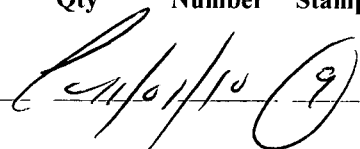



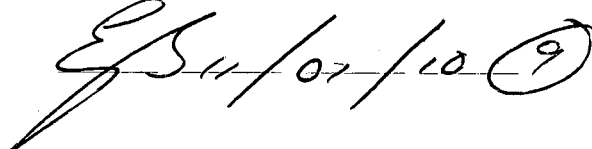
Work Order ID 64757

Thursday, December 16, 2010 9:49:18 AM

Page 3

Item ID:	D2348	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate				Stop	
Start Date:	12/16/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	12/21/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo Ensure certificate of conformity is attached	0.00							
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo INSPECT CERTS	0.00							
180  Small Fab	Small Fab	0.00							
Small Fab	Memo Install Insert as per Dwg D2348	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 12/21/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 11

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12
me
11-01-10

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, December 16, 2010 9:49:22 AM

Page 1

Work Order ID: 64757

Parent Item: D2348

Parent Item Name: Wearplate




Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	149.1340	0.0198	0.125053			

1810-12-16

Location	Loc Qty	Loc Code
MAT	111	
116308	111	
MAT21	38.134	
113608	38.134	

19

D3996-FE-832-EF

Manufactured No



Self-Clinching Fastener

180 Each 61.0000 4

24

113608
EP 11/01/10

Location	Loc Qty	Loc Code
ST107	61	
54162	61	

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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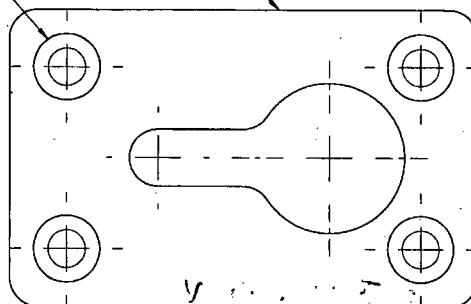
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

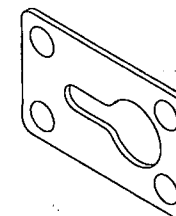
D2348F



D2348 WEAR PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64757

2/10-12-16



RELEASED
2009-11-09
NA

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO B-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>97</i>		
CHECKED	<i>97</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>97</i>	D2348	SHEET 1 OF 2
APPROVED	<i>97</i>	TITLE	SCALE
DE APPR.	<i>97</i>	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

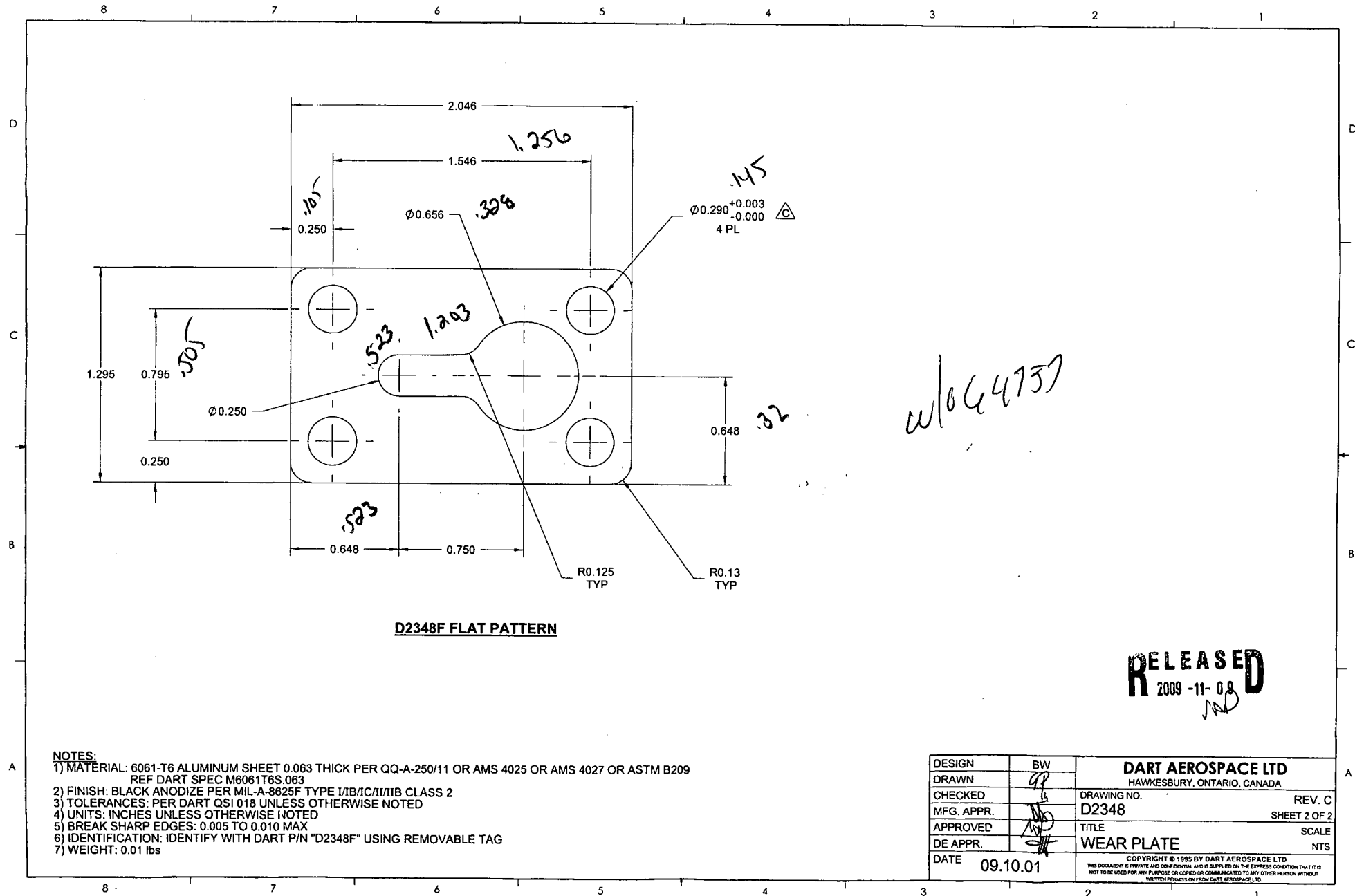
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13162

Purchase Order Date 12/17/10

PO Print Date 12/17/10

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name
Vendor Phone 514 429 7777
Vendor Fax 514 429 5108
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
CONFIRMED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	64757	D2348 WEARPLATE	12/23/10 Yes	9.00	Purolator ground	\$11.1111	\$100.00

Special Inst: BLACK ANODIZE PER MIL-A-8625F
TYPE I/IB/IC/II/IIB
CLASS 2

PO Total: \$100.00

CERTIFICATE OF CONFORMITY
ISSUED UPON DELIVERY

Change Nbr: 1

Change Date: 12/17/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



21 chemin de l'Aviation, Pointe-Claire
QC H9R 4Z2
Canada
Phone: 514-429-7777 Fax: 514-429-5108
EMail: info@tnminc.ca

Packing Slip

DATE

PACKING SLIP #

1/7/2011

- 88769



BILL TO:

SHIP TO:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
13162	0094	NET 30		1/7/2011	Purolator		130224-001

PO Line#: 1

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
9	9	0	P/N: D2348 TNM-REV:1

Sign Here: _____

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.



Anodisation & Peinture TNM Inc
21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2
Telephone 514-429-7777 Fax 514-429-5108
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 88769



1/7/2011

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

PURCHASE ORDER /
NO. DE COMMANDE:

13162

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	9	9	P/N: D2348 TNM-REV:1 B64757 WEAR PLATE MAT'L: ALUM	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

Silvico

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.
NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed: _____



Directeur de la Qualité / Q.A. Manager